

ASAP!

Date: Thursday, 15/05/2008 8:10:00 AM
User: Linda Lacelle



Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE	
Job Number : 39278 - 1		
Estimate Number : 13315		
P.O. Number :	Part Number : D37933	<div style="border: 1px solid red; border-radius: 50%; padding: 5px; display: inline-block;">POSITIVE RECALL</div> <i>split</i> <i>R</i>
This Issue : 15/05/2008 S.O. No. :	Drawing Number : PRELIM	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : R & D SM/MED FAB	Drawing Revision : PRELIM	
Previous Run : 39253	Material :	
Written By :	Due Date : 22/05/2008	Qty: 40 Um: Each
Checked & Approved By :		
Comment : Est Rev:A 08-05-13 new issue DD verified by:		

Additional Product

PRELIMINARY ISSUE

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		
	<i>1.298</i> Comment: Qty.: 0.5733 sf(s)/Unit Total : <i>51.907</i> 22.9320 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: <i>107909</i> <i>IB 8-5-20</i>	
2.0	WATER JET	FLOW WATER JET
		
	Comment: FLOW WATER JET 1-Cut as per Dwg D3793 Dwg Rev: <i>A</i> <i>IB 8-5-20</i> Prog Rev: <i>A</i> 2-Deburr if necessary <i>IB 8-5-20</i> <div style="float: right; border: 1px solid blue; border-radius: 50%; padding: 10px; text-align: center;"> <i>pk</i> → </div>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	<i>IB 8-5-20</i> Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK <i>5 08/05/21 x</i>	
5.0	BRAKE NC	NC BRAKE
		
	Comment: NC BRAKE 1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs <div style="float: right; border: 1px solid blue; border-radius: 50%; padding: 10px; text-align: center;"> <i>pk</i> </div>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3793-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: <u>39278</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/5/21	#	Parts has been modified to meet new Eng. change. Parts were all ready in Production. Before change was sent.	RE QSI 042 08.05.21	Parts are accepted as per Eng. change. Re-work	RE-5 08/5/21	QSI 042 08.05.21	08/5/21	
		A 0.531" x 0.780" obscured also: also was plate 6547 was changed from 6.444.						

NOTE: Date & initial all entries

Date: Thursday, 15/05/2008 8:10:00 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39278

Part Number: D37933

Job Number:



Seq. #:

Machine Or Operation:

Description:

~~3 Form Joggle on brake using jig as per Dwg D3793~~ 08/05/15

6.0

QC5

INSPECT WORK TO CURRENT STEP



(Pb) →

Comment: INSPECT WORK TO CURRENT STEP

08/05/21 (12)

7.0

POWDER COATING

POWDER COATING



M105642



(12X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45 PM
220°F
2:15

M.A.

08/05/21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/05/21

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(12X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F.P-17

M.A.

08/05/22

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-22

POSITIVE RECALL
EFFECTIVE 08/05/15 AUTH JL
RELEASED 08/05/22 DATE 08/05/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

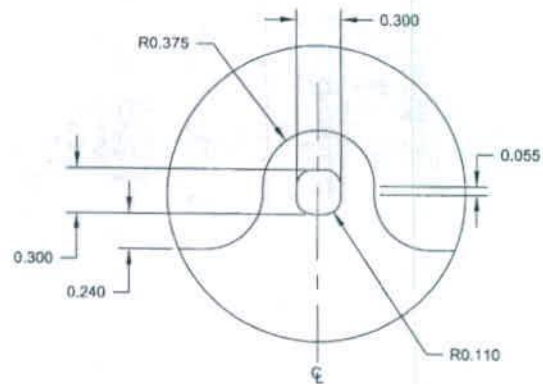
Part No: D 3793-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

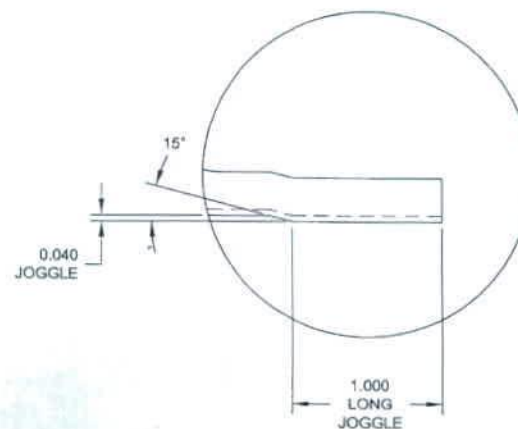
NCR: <u>39278</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/21	1	two wear plates have the $\phi 0.531$ " holes at $\phi 0.550$ " R.C. Re-closing on water jet	per QSI 042 08.05.21	Part is acceptable acceptable	per QSI 042 08.05.21	08/05/21	per QSI 042 08.05.21	08/05/21

NOTE: Date & initial all entries

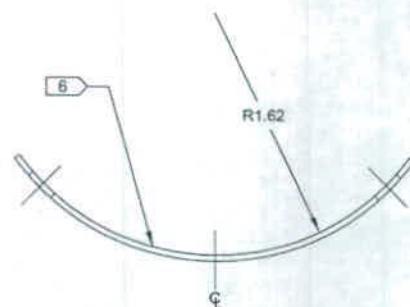




DETAIL A
SCALE 10X



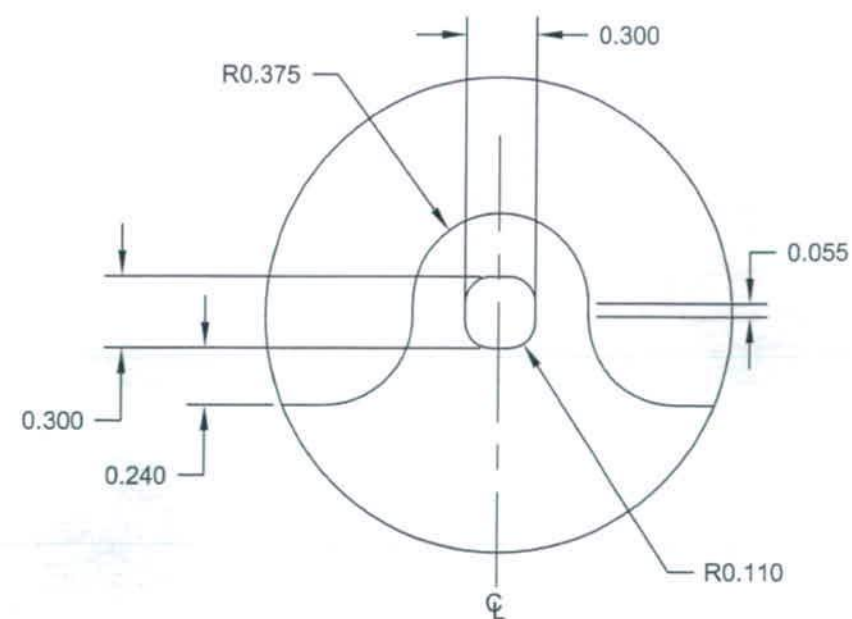
DETAIL B
SCALE 10X



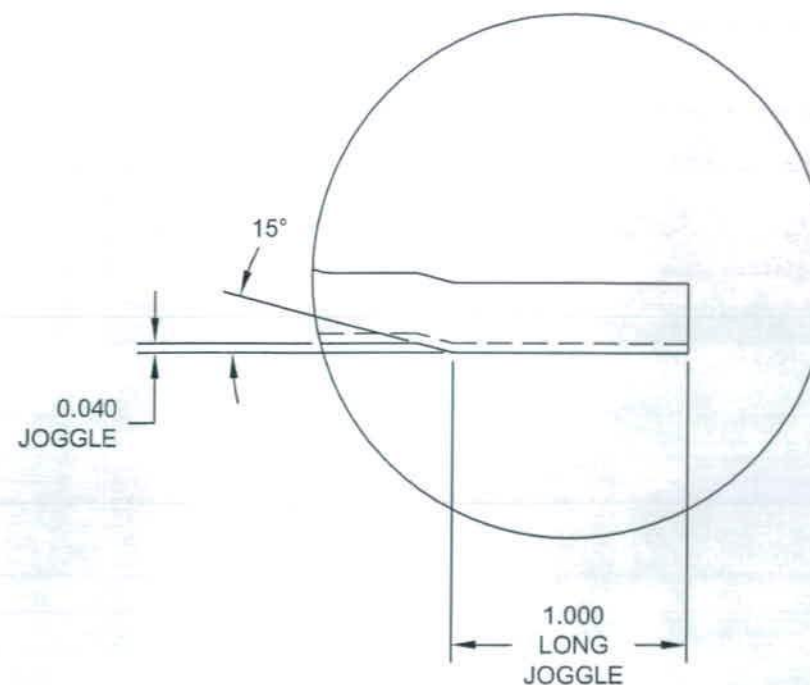
SECTION C-C
SCALE 10X

RELEASED
08-05-14

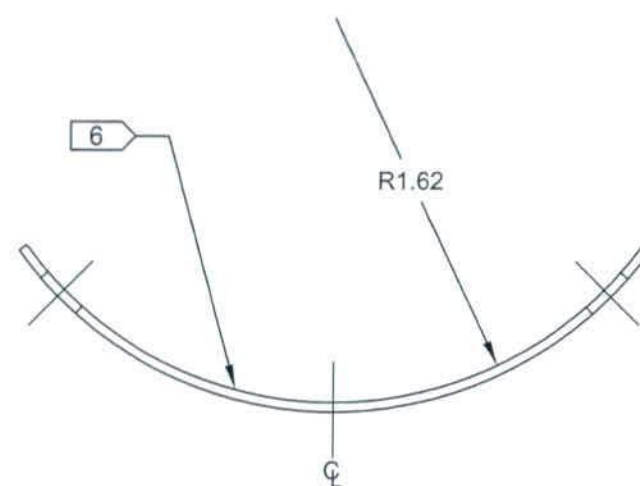
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
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DETAIL A
SCALE 10X



DETAIL B
SCALE 10X

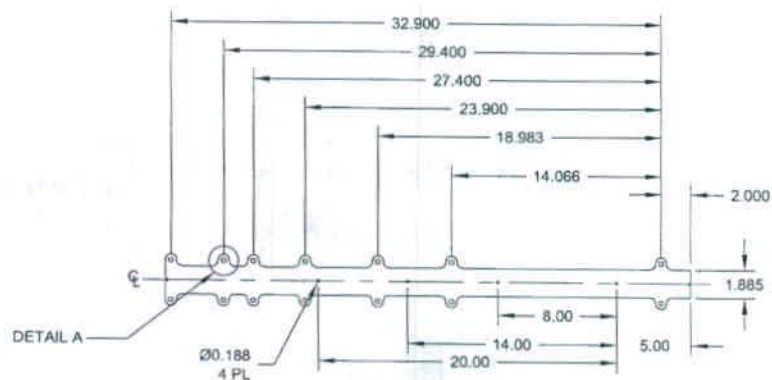


SECTION C-C
SCALE 10X

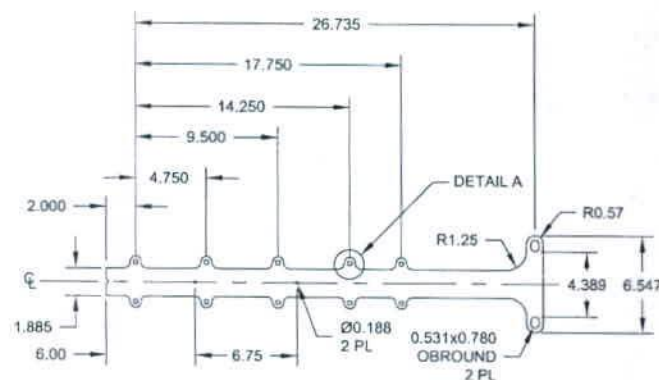
PRELIMINARY ISSUE
06.05.21

DESIGN	<i>PL</i>	DART AEROSPACE USA, INC	
DRAWN	<i>PL</i>	PORT HADLOCK, WA	
CHECKED	<i>PL</i>	DRAWING NO.	REV. A
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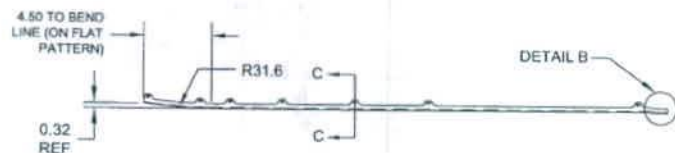
123456789



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08-05-23/18

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	PH	08.05.14
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 1 OF 2
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DE APPR.	PH	WEARSHOE	NTS
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D3793-1 BEND DETAIL

(MAKE FROM D3793-1F)



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL

(MAKE FROM D3793-3F)



PRELIMINARY ISSUE
pt 08.05.21

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
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DESIGN	<i>PH</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. 1
MFG. APPR.	<i>PH</i>	D3793	SHEET 1 OF 1
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